

Work Order ID 57616

April 12, 2010 8:19:42 AM

Page 1

Item ID: D2571

Accept

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 19/04/2010 Start Qty: 8.00

Required Date: 19/04/2010 Req'd Qty: 8.00

Reference:

10.04.13

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. *DIP* Double check by: *DIP* 11-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets: 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets: 3-Machine Step No 3 per Folio FA051 and inspect

10/04/14

8

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2571 & D2572

DIP 10/04/18

8

1
PTO
last page

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

DIP 10/04/18

8

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 02571 PAR #: _____ Fault Category: machining NCR: Yes No DQA: _____ Date: 10/04/19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/04/27

NCR: <u>57616</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/19	100	4 machining app is off because origline in "A" was not well taken. Part is machine cracked QC operator error	<u>JSIMU2</u>	re-took at the scrap and replace <u>M 46412 x 1</u>	<u>JSIMU2</u> 10/04/19	<u>JSIMU2</u> 10-4-19	<u>JSIMU2</u>	<u>10-04-19</u>
		↳ did not take "A" Origine in the morning ↳ Lost "A" origine over night.....	<u>JSIMU2</u>					

NOTE: Date & initial all entries

Work Order ID 57616

April 12, 2010 8:19:42 AM



Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 19/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00AM

8:30AM FINISH TIME:

OVEN TEMPERATURE:

320°F

SP 10/04/19

8 1

HL 10/04/20

8 0

⇒ HL 10/04/21

8 0

Work Order ID 57616

April 12, 2010 8:19:42 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 19/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑤ BR 10-4-21.

170

Identify as per dwg & Stock Location:

ST 433

0.00



Packaging

Memo

0.00

Packaging

mk 10/04/26 (8X)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 J

MF
10-4-27

Picklist Print

April 12, 2010 8:19:41 AM

Page 1

Work Order ID: 57616



Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 19/04/2010

Required Date: 19/04/2010

Comments: IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 [KJ:]

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	51.0000	8.0000			



Saddle Billet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT42

51

46412

51



9
10/04/14

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443			0.441	0.441	0.441		
B	1.745	1.755			1.750	1.750	1.750		
C	3.495	3.505			3.500	3.500	3.500		
D	1.745	1.755			1.750	1.750	1.750		
E	7.990	8.010			8.004	8.004	8.004		
F	0.490	0.510			0.502	0.497	0.499		
G	0.257	0.262			0.260	0.259	0.259		
H	0.375	0.380			0.378	0.378	0.378		
I	0.490	0.510			0.498	0.499	0.501		
J	1.174	1.184			1.179	1.179	1.179		
K	0.558	0.578			0.563	0.565	0.568		
L	1.174	1.184			1.179	1.179	1.179		
M	1.490	1.500			1.495	1.495	1.495		
N	2.495	2.505			2.500	2.500	2.500		
O	3.869	3.879			3.874	3.874	3.874		
P	0.115	0.135		0.126	0.127	0.126	0.128		
Q	0.115	0.135			0.135	0.135	0.135		
R	0.240	0.260		0.255	0.255	0.255	0.256		
S	0.115	0.135			0.135	0.135	0.130		
T	0.178	0.198			0.188	0.188	0.188		
U	2.940	2.980			2.960	2.960	2.960		
V	0.230	0.250			0.237	0.235	0.236		
W	0.115	0.135			0.127	0.125	0.123		
X	0.308	0.313			0.3105	0.310	0.310		
Y	0.760	0.765			0.763	0.763	0.764		
Z	0.352	0.372			0.368	0.363	0.363		
AA	0.470	0.530			0.500	0.500	0.500		
AB	0.615	0.635			0.627	0.628	0.626		
AC	0.053	0.073			0.063	0.063	0.063		
AD	0.240	0.260			0.255	0.255	0.252		
AE	1.375	1.395		1.384	1.3875	1.3895	1.390		
AF	0.115	0.135			0.130	0.130	0.130		
AG	0.240	0.280			0.250	0.250	0.250		
AH	0.240	0.260			0.252	0.249	0.250		
AI	2.000	2.020		2.002	2.0025	2.0045	2.005		
AJ	0.023	0.043			0.033	0.033	0.033		
Accept/Reject				Reject					

Measured by: 	Audited by: 
Date: 10/04/17	Date: 10/04/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 	


DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

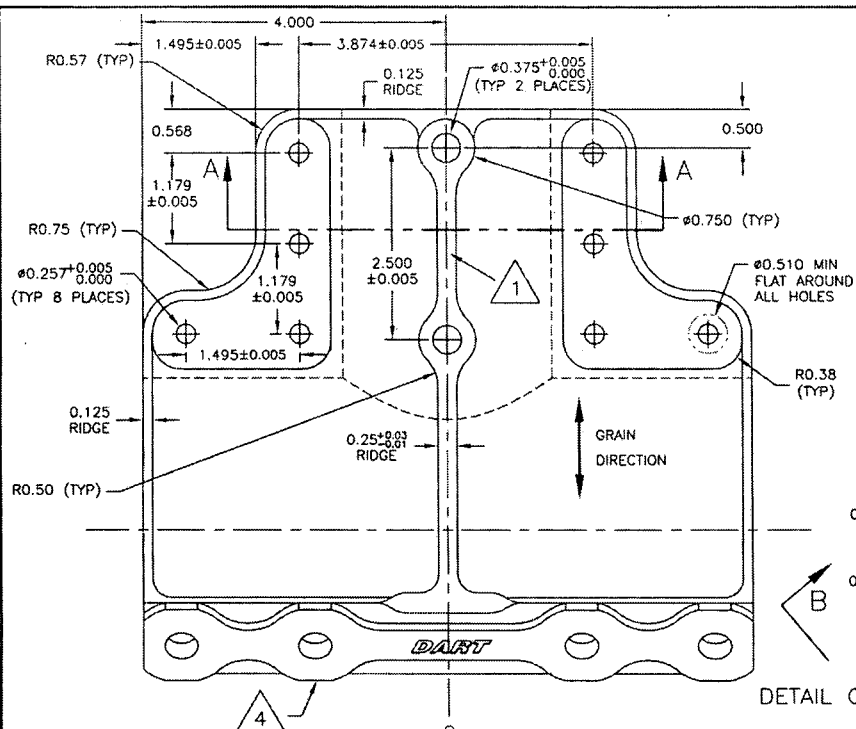
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	9
A	0.438	0.443		0.441	0.441	0.441	0.441		0.441
B	1.745	1.755		1.750	1.750	1.750	1.750		1.750
C	3.495	3.505		3.500	3.500	3.500	3.500		3.500
D	1.745	1.755		1.750	1.750	1.750	1.750		1.750
E	7.990	8.010		8.004	8.004	8.004	8.004		8.004
F	0.490	0.510		0.4935	0.496	0.496	0.496		0.505
G	0.257	0.262		0.260	0.260	0.260	0.260		0.260
H	0.375	0.380		0.378	0.378	0.378	0.378		0.378
I	0.490	0.510		0.498	0.499	0.499	0.500		0.500
J	1.174	1.184		1.179	1.179	1.179	1.179		1.179
K	0.558	0.578		0.565	0.567	0.567	0.568		0.568
L	1.174	1.184		1.179	1.179	1.179	1.179		1.179
M	1.490	1.500		1.495	1.495	1.495	1.495		1.495
N	2.495	2.505		2.500	2.500	2.500	2.500		2.500
O	3.869	3.879		3.874	3.874	3.874	3.874		3.874
P	0.115	0.135		0.126	0.129	0.127	0.127		0.127
Q	0.115	0.135		0.135	0.135	0.135	0.135		0.135
R	0.240	0.260		0.256	0.256	0.256	0.256		0.256
S	0.115	0.135		0.135	0.132	0.132	0.133		0.133
T	0.178	0.198		0.188	0.188	0.188	0.188		0.188
U	2.940	2.980		2.960	2.960	2.960	2.960		2.960
V	0.230	0.250		0.236	0.238	0.237	0.240		0.237
W	0.115	0.135		0.125	0.125	0.125	0.125		0.125
X	0.308	0.313		0.3105	0.310	0.310	0.310		0.310
Y	0.760	0.765		0.763	0.763	0.763	0.763		0.763
Z	0.352	0.372		0.363	0.363	0.362	0.364		0.363
AA	0.470	0.530		0.500	0.500	0.500	0.500		0.500
AB	0.615	0.635		0.628	0.628	0.628	0.628		0.628
AC	0.053	0.073		0.063	0.063	0.063	0.063		0.063
AD	0.240	0.260		0.255	0.255	0.258	0.256		0.256
AE	1.375	1.395		1.3895	1.391	1.3890	1.3890		1.389
AF	0.115	0.135		0.130	0.130	0.130	0.130		0.130
AG	0.240	0.280		0.259	0.250	0.250	0.250		0.250
AH	0.240	0.260		0.254	0.249	0.251	0.251		0.250
AI	2.000	2.020		2.004	2.0055	2.004	2.004		2.004
AJ	0.023	0.043		0.033	0.033	0.033	0.033		0.033
Accept/Reject									

Measured by: DTP	Audited by: RF
Date: 10/04/17	Date: 10/04/17






Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

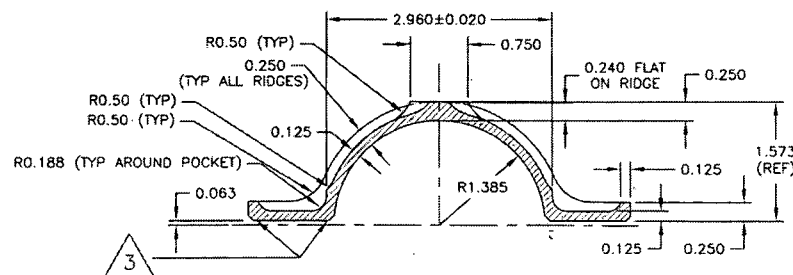
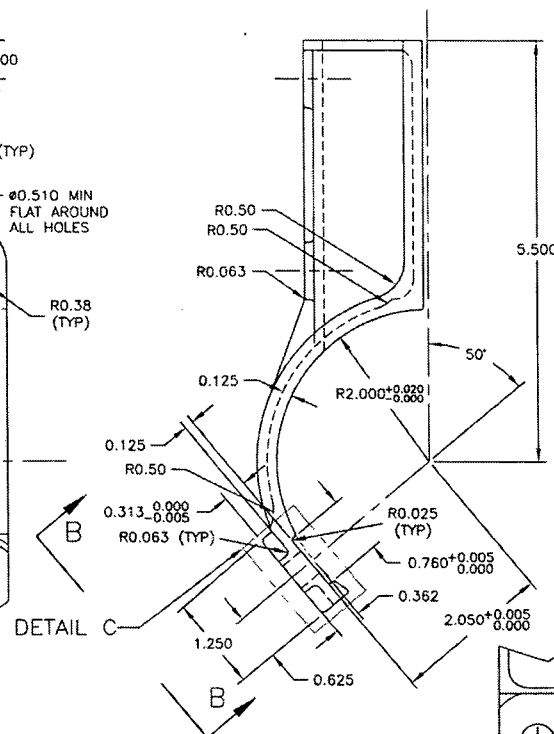
05-12 d 



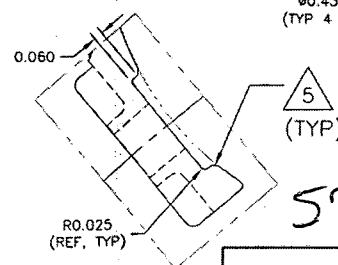
NOTES

MATERIAL: 7075-17351 (QO-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

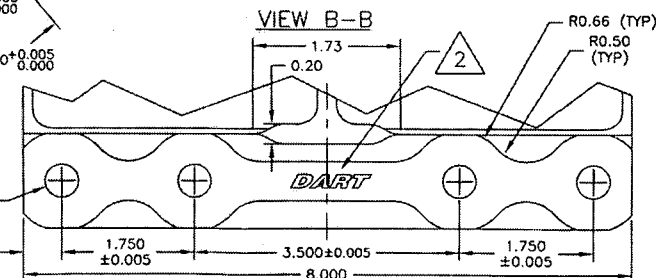
- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |












SECTION A-A



DETAIL C
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5								
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES								
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177								
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425								
A	96.09.16	NEW ISSUE								
<table border="1"> <tr> <td>DESIGN DS</td> <td>DRAWN BY PH</td> <td rowspan="2">  DART AEROSPACE LTD. <small>MARKHAM, ONTARIO, CANADA</small> </td> </tr> <tr> <td>CHECKED </td> <td>APPROVED </td> </tr> <tr> <td colspan="2">DATE 05.07.13</td> <td> DRAWING NO. D2571 TITLE OUTER FWD SADDLE </td> </tr> </table>			DESIGN DS	DRAWN BY PH	 DART AEROSPACE LTD. <small>MARKHAM, ONTARIO, CANADA</small>	CHECKED 	APPROVED 	DATE 05.07.13		DRAWING NO. D2571 TITLE OUTER FWD SADDLE
DESIGN DS	DRAWN BY PH	 DART AEROSPACE LTD. <small>MARKHAM, ONTARIO, CANADA</small>								
CHECKED 	APPROVED 									
DATE 05.07.13		DRAWING NO. D2571 TITLE OUTER FWD SADDLE								
		REV. 1 OF 2 SHEET 1 OF 2								